

Date: Thursday, 25/09/2008 10:50:56 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT BLADE FOLD ASSEMBLY
Job Number : 41291 -2	
Estimate Number : 13532	
P.O. Number :	Part Number : PB674300103
This Issue : 25/09/2008 S.O. No. :	Drawing Number : B6743001 P.1,3,4,15
Prsht Rev. : NC	Project Number : N/A
First Issue : 18/08/2008 Type : SMALL /MED FAB	Drawing Revision : B1
Previous Run : 41239	Material :
Written By :	Due Date : 15/09/2008 Qty: 4 U/m: Each
Checked & Approved By : MF 08-09-25	
Comment : Est Rev:A 08-07-30 new issue DD verified by:ec	

Additional Product MS246945102 → M14604 QTY8 (FOR D3440-1)
AN6C16A BOLT → M105831 → 8Qty

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PB674300109	Aft Blade Fold Assembly Weldment
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Aft Blade Fold Assembly Weldment
batch: 41363

MF 08-10-24

2.0	PB674300113	Aft Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Aft Adjustable Blade Support Assembly
batch: 41366

MF 08-10-24

3.0	PB674300117	Aft Adjustable Blade Support Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Aft Adjustable Blade Support Assembly
batch: 41368

MF 08-10-24

4.0	PB674300121	PB67-43001-21
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
PB67-43001-21
batch: 41370

MF 08-10-24

5.0	PB674300123	PB67-43001-23
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
PB67-43001-23
batch: 41371

MF 08-10-24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Part Number: PB674300103

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Seq. #:	Machine Or Operation:	Description :
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6.0	PB674300137	PB67-43001-37
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2 4.0000 Each(s)
PB67-43001-37
batch: 41379

mf 08-10-21

7.0	PB674300157	Stabilizer Arm
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2 4.0000 Each(s)
Stabilizer Arm
batch: B41014 x 2

mf 08-10-21

8.0	PB674300159	PB67-43001-59
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
PB67-43001-59
batch: B406 x 1, 1 x

mf 08-10-21

9.0	PB674300163	Handle Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Handle Assembly
batch: 41384

mf 08-10-21

10.0	PB6743001135	Male Eye
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Male Eye
batch: B239954

mf 08-09-25

11.0	PB6743001155	Pin
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Pin
batch: B41906 x 4

mf 08-09-25

12.0	PB6743001261	Lever Arm
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4 8.0000 Each(s)
Lever Arm
batch: B41294 x 4

mf 08-10-21

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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PB6743001265

Bushing



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Bushing

batch: B41373

MF 08-09-25

14.0

PB6743001299

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total: 8.0000 Each(s)

Bushing

batch: B40062

MF 08-09-25

15.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B41005~~

x2mx B41354 x2

MF 08-09-25

16.0

D3451045

Handle and Lock-Down Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Handle and Lock-Down Assembly

batch: ~~B41064~~

x2mx x 41353

MF - 08-09-25

17.0

D34401

Tube Guide (Supersedes B67-43001-25/-307)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Tube Guide

batch: B41347

MF 08-09-25

18.0

D34403

Clamp (Supersedes B67-43001-309)



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Clamp

batch: B41277

MF 08-10-24

19.0

D34441

Velcro Loop Belt



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Velcro Loop Belt

batch: B339165

MF 08-10-24

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Job Number:



Seq. #:

Machine Or Operation:

Description :

20.0

D34479

Swing Arm



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)
Swing Arm
batch: 841352

MF 08-10-24

21.0

086004

Inventory



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Inventory
batch: m17850

MF 08-10-24

22.0

MS27039107

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
Screw
batch: m108057

MF 08-10-24

23.0

MS27039123

SCREW



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)
SCREW
batch: m18057

MF 08-10-24

24.0

MS21042L4

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 52.0000 Each(s)
Nut
batch: m104683x10, m107499x19, m108552x15, m105054x8

MF 08-10-24

25.0

MS21042L6

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)
Nut
batch: m108183x5, m105077x11

MF 08-10-24

26.0

MS518596

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)
WASHER
batch: m17890x4, m108986x20, m108473x8

MF 08-10-24

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Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

27.0

MS518598

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m108986

mf 08-10-24

28.0

NAS43DD368

SPACER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch: m109060

mf 08-10-24

29.0

NAS1149F0316P

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

batch: m108473

mf 08-10-24

30.0

NAS1149F0432P

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Washer

batch: m18057

mf 08-10-24

31.0

NAS1149F0632P

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

WASHER

batch: m18057

mf 08-10-24

32.0

NAS1149F0832P

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

WASHER

batch: m18057

mf 08-10-24

33.0

AN960JD6

Washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

batch: 6085

mf 08-10-24

Date: Thursday, 25/09/2008 10:50:57 AM
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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

34.0

AN410A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:

m105442 x 5, m101291 x 1, m107178 x 2, MF 08-10-24

35.0

AN413A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

batch:

m109282

MF 08-10-24

36.0

AN416A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Bolt

batch:

m19278

MF 08-10-24

37.0

AN611A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch:

m105558

MF 08-10-24

38.0

AN620A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Bolt

batch:

m104547

MF 08-10-24

39.0

AN813A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

BOLT

batch:

m108986 x 2, m18180 x 6

MF 08-10-24

40.0

BSP43

RIVET



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

RIVET

batch:

m109119

MF 08-10-24

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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

41.0

CR3213405

cherry rivet



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
cherry rivet
batch: m104214

mf 08-10-24

42.0

MS17984C413

PIN, QUICK RELEASE



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
PIN, QUICK RELEASE
batch: m15119 x 3, m108986 x 1

mf 08-10-24

43.0

MS17984C418

PIN, QUICK RELEASE



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)
PIN, QUICK RELEASE
batch: m108986

mf 08-10-24

44.0

30345T21

LANYARD



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
LANYARD
batch: m107827

mf 08-10-24

45.0

30345T24

LANYARDS



Comment: Qty.: 3.0000 Each(s)/Unit Total: 12.0000 Each(s)
LANYARDS
batch: m108390 x 9, m108973 x 3

mf 08-10-24

46.0

240107

SPRING SLOTTED PIN



Comment: Qty.: 9.0000 Each(s)/Unit Total: 36.0000 Each(s)
SPRING SLOTTED PIN
batch: m102940 x 30, m17850 x 6

mf 08-10-24

47.0

3408A98

DETENT BALL SPRING PLUNG



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
DETENT BALL SPRING PLUNG
batch: m102312 x 3, m17828 x 1

mf 08-10-24

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Job Number: 41291

Part Number: PB674300103

Job Number:



Seq. #:

Machine Or Operation:

Description :

48.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per dwg and use 242 threadlock A/R shown on dwg PB67-43001 page 2.

242 THREADLOCK batch: M107045

M.F.
Pl 08-10-24

49.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/10/24 x2

50.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BPA 41180

B 41181

Lo

51.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

H 08/10/24

Job Completion



△ Add - PB6743001-305 x2 B 40063

MF 08-10-24

NOTICE: INFORMATION CONTAINED HEREIN IS PRELIMINARY TO THE PREMIER AVIATION, INC. AND MAY NOT BE RELEASED OR REPRODUCED WITHOUT PRIOR WRITTEN AUTHORIZATION BY PREMIER AVIATION, INC.

NOTES (UNLESS OTHERWISE SPECIFIED):

1. IDENTIFY PARTS PER PREMIER IDENTIFICATION AND MARKING PROCEDURES 115-12112. LOCATION, CHARACTER HEIGHT, AND PROCESS AS INDICATED. MARK IN CONTRASTING COLOR.
2. FOR SHEET METAL PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .01-.03, EXCEPT AS NOTED. FOR MACHINED PARTS, REMOVE ALL BURRS AND BREAK ALL EDGES/CORNERS .015 MAX, EXCEPT AS NOTED.
3. GENERAL SHOP PRACTICES I.A.W. PREMIER SPEC. 008-93000 AND AC43.13.
4. OPEN
5. WELD PARTS PER MIL-2219, CLASS B.
6. CHEN FILM (ALODINE) ALL ALUMINUM DETAIL PARTS PER PREMIER SPEC 008-93003, CLASS 1A, AND PRIME WITH (POST PRIMER PER MIL-P-23377C, ZINC CHROMATE PRIMER PER MIL-177-1757, OR EQUIVALENT).
7. STITCHING PER FED-STD-751.

WITH THE INNER TUBE CRADLE ASSEMBLY LOCKED IN ITS MOST EXTENDED POSITION (7-HANDLE LOCKED ON LOWEST HOOK), DRILL A .25 DIA HOLE THROUGH THE OUTER TUBE .35 BELOW THE BOTTOM OF THE INNER TUBE AND INWARD FROM THE OUTER SIDE OF THE OUTER TUBE. UNLOCK THE INNER TUBE CRADLE ASSEMBLY AND MOVE IT TO ITS LOWEST, MOST RECESSED POSITION. MATCH DRILL THE INNER TUBE TO THE HOLE JUST DRILLED IN THE OUTER TUBE, .25 DIA.

INSTALL TITAN TUBE BUSHING INSIDE THE OUTER TUBE. MATCH DRILL BUSHING TO EXISTING HOLES IN OUTER TUBE USING 1/8" DIAMETER DRILL. INSERT 803073 SET PIN, AND GRIND FLUSH WITH CONTOUR OF OUTER TUBE. 8 PL 42 PL EA BUSHING)

GRIND BUSHING AND WELD TO CONTOUR OF TUBE.

ALIGN CRADLE ASSEMBLY 90 DEGREES FROM THE CENTERLINE AXIS OF THE BUSHING ON THE OTHER END OF THE TUBE. WELD GUSSET ON CENTER WITH TUBE AND BOTTOM OF CRADLE ASSEMBLY.

CHAMFER EDGE FOR BETTER WELDING.

TAP HOLE TO 1/4-20 THRU.

INSTALL CL-40-SBP-3 DETENT BALL INTO HOLDING FIXTURE SO THAT THE BALL IS POSITIONED SLIGHTLY ABOVE FLUSH WITH THE TUBE SEAT SURFACE. ALIGN THE TUBE IN THE FIXTURE AND MARK THE BALL CONTACT LOCATION ON THE TUBE. USE A SMALL PUNCH TO DIMPLE THE TUBE AT THE MARKED LOCATION. INSERT THE TUBE BACK INTO THE FIXTURE AND ADJUST FOR PROPER STOWING.

15. PERMISSIBLE TO SUBSTITUTE EQUIVALENT AN860 WASHER FOR NAS1149 WASHER UNTIL CURRENT STOCK IS DEPLETED.
16. PAINT ALL ASSEMBLIES AND WELDMENTS AS REQUIRED, EXCEPT WHERE NOTED, 23663U W OHSA YELLOW, PER FED-STD-525.

NO PAINT REQUIRED, CHEN FILM ONLY WHERE APPLICABLE, PER PREMIER SPEC 008-93003.

STITCH APPROX AS SHOWN, PER FED-STD-751.

PERMISSIBLE TO TRIM NYLON WASHERS OR SUBSTITUTE WITH THINNER WSS1859 EQUIVALENT.

DISENGAGE -53 HANDLE ASSY (BOTH SIDES) PRIOR TO INSTALLATION AND REMOVAL OF -01 OR -02 BLADEFOLD ASSY TO AIRCRAFT.

SECURE -43 BELT ASSY TO TOP OF -85 (01 -85) OR -47 (01 -61).

LOCATE APPROX AS SHOWN.

WITH -137 SLEEVE IN OPEN POSITION, LOCATE RIVET APPROX AS SHOWN, TO SERVE AS A STOP FOR -137

DRILL WITH -37 AT VERTICAL FULL OPEN POSITION. DRILL ADDITIONAL HOLE WITH -37 AT FULL CLOSED POSITION, ASSURING -37 CLEARS ADJACENT STRUCTURE.

SHIM AS REQD, USING NAS1149D0332J WASHERS.

-01 TWO BLADEFOLD ASSY FOR COMMERCIAL VERSIONS ONLY
-02 TWO BLADEFOLD ASSY FOR CANADIAN VERSIONS ONLY

26. TOLERANCE ON DECIMAL .X ± .1

27. LAST SECTION LETTER USED "L"

DRILL NO. 30 (65.128) HOLE THRU -37 AND AND -25 (COMPONENT OF -09 ASSY). INSERT 803073 SET PIN, AND GRIND FLUSH WITH -37.

REFERENCE ONLY

REVISIONS			
REV	DESCRIPTION	DATE	APPROVED
1	MFG. RELEASE	10/12/75	NH
2	CHANGES TO IMPROVE FUNCTIONALITY	3/7/76	NH
3	DWG AND P/L REVISED AND UPDATED TO REFLECT BELT MODIFICATIONS	8/16/76	NH
4	CHANGED DOORWAY AFTER FIT	10/30/76	NH

FUNCTION: TEST CASE TP-D42-645-1

RELEASED
06.01.20

ECO
5007
5161
6262

SEE SEPARATE PARTS LIST B67-4300IPL

MATERIAL		MULTIPLE OTHERS SPECIFIED:		DRAWN BY: <i>R. W. L.</i>		DATE: 10/12/75		PREMIER AVIATION, INC.	
SHEET 1 OF 1		SHEET 1 OF 1		CHECKED BY: RICK REYNOLDS		DATE: 10/12/75		800 Aviation Parkway, Grand Prairie, Texas 75050	
TITLE		TITLE		APPROVED BY: WALT HAMAKER		DATE: 10/12/75		BLADE FOLD KIT	
PART NO.		PART NO.		RELEASED BY:		DATE:		A/JET KNOB (PART NO. 01) DNG NO.	
B67412		B67412		PRO/ENGINEER		DATE:		D OSUV8 B67-43001	
B67412		B67412		DATE:		DATE:		REV. B	

ORIGINAL



